Work Order ID 50650

E

July 20, 2009 9:09:52 AM

Item ID:

D2282-041

Revision ID:

Item Name:

Start Date:

07/20/2009

T Assembly

Required Date: 07/27/2009

Start Oty: 50.00 Req'd Qty: 50.00

Accept

Setup Start

Stop



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-07-20 Tooling:

Date:

Date: Date: Run

Start

Stop

Sequence ID/

Operation

Set Up/

SPC (Y/N):

Draw

Draw

Plan Code

Reject

Reject Insp.

Work Center ID Draw Nbr

Large Fab

Description **Revision Nbr**

Run Hours

Number

Rev.

Accept Otv

Oty

Number

Stamp

D2282

Rev E

OC:

Large Fab

Memo

0.00

0.00

0.00

0.00

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly: Grind chamfers and ensure full penetration as per dwg D228211 ****** brush weld right after welding, to take color off ****** : A/RER316L SS Filling Rod H 103-42

16. 50.00 02

110

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

120

Small Fab

Small Fab

Memo

Small Fab

Tumble

9-7-37

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES									
DATE STEP		PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	•	PAR #:	Fault Categ	CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: RDER NON-CONFORMANCE (NCR) Corrective Action Section B Action Description Sign & Section C Section C Chief Eng QC Inspector								
					QA:	N/C Close	d:	_ Date: _	<u> </u>			
NCR:		,			MANCE (NO	R)						
DATE	STEP	Description of NC				Verifi	cation	Approval	Approval			
NCR:		Section A	Initial Chief Eng	Chief Eng	Dat	te Sect	ion C	Chief Eng	QC inspector			
			1 +						1			

Work Order ID 50650

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D2282-041

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Item Name:

T Assembly

Start Date:

07/20/2009

Start Qty: 50.00

Required Date: 07/27/2009

Req'd Qty: 50.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/ Work Center ID

130

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ **Run Hours**

0.00

=> Soglata7

Rev. Number

Draw

Draw Plan Code

Accept Qty Qty

Run

Reject

Reject Insp. Number Stamp

140

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09607/274J

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANGE	ES				• *
DATE STEP		PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cateç	Jory:	NCR: Yes No DQA: Date: _				
					QA: N	C Close	d:	_ Date: _	•
NCR:		1	NORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
NCR:	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
	-								
	i	1							

Picklist Print

July 20, 2009 9:09:52 AM

Work Order ID: 50650

Parent Item:

D2282-041RevE

Parent Item Name: T Assembly

Comments:



Start Date: 07/20/2009

Required Date: 07/27/2009

Start Qty: 50.00

Required Qty: 50.00

Component	Item	ID
Item Name		

Replacement Mfg/ Item ID

Purch

Primary Item Location Last Location Route Seq ID

Unit of Measure

Remaining Qty on Qty To Pick Issued Hand

Qty

Date Status Issued

D2282-3RevE

Tube

Manufactured	No

No

100

Each

79.0000 50.0000

		<u>Warehouse</u>	<u>Lo</u>	c Qty	Loc Code
		Location			
		Main Warehouse			
		ST		79	
		46428		29	
		_ 48279		50	
Manufactured	No		100	Each	113.0000 50.0000

25-fo.pop

D2282-5RevE



Tube

<u>Warehouse</u> Location	Loc Qty	Loc Code	
Main Warehouse			
ST	113		
46429	68		
48281	45		

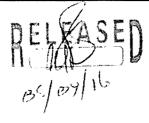
50. Sp 09.07. 20

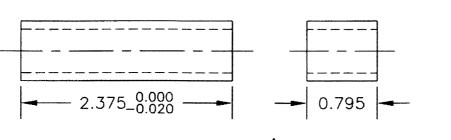
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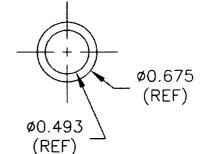
W/O:			WC	RK ORDER CHANGE	S			ε '
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								į
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date:	
					QA: N	/C Closed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		
		Description of NC	Description of NC Corrective Action			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector



	DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECK	(ED:	APPROVED	DRAWING NO. REV. E
		W	1/400	D2282 SHEET 1 OF 2
	DATE			TITLE SCALE
	05.0	6.07		HANDLE TUBES 1:1
,	Α		94.10.14	NEW ISSUE
	В		95.03.23	RE-DESIGN
	С		97.10.20	CORRECTED NUMBERING SCHEME
	D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
	E		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030







D2282-3



D2282-7

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

R0.063 × 0.063 DEEP

0.090 × 45°
CHAMFER

0.125
(REF)

D D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

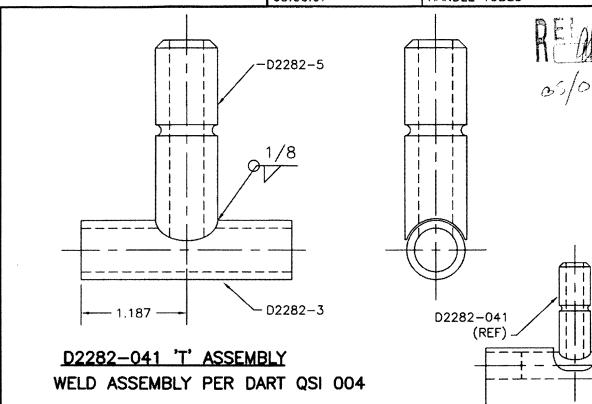
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Dart Ae	rospace	Lta							
W/O:			WC	RK ORDER CHANGI	ES				10011
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No.	No:PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) TE STEP Description of NC Corrective Action Section B Verification Approval								
raitivo	-	PAN#	Fauit Cateç	jory					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	n B	Vorifi	ration	Approval	Annroval
DATE	STEP			Action Description Chief Eng				Chief Eng	QC Inspector
···									



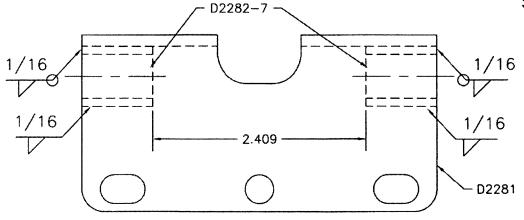
DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	11115	D2282	SHEET 2 OF 2
DATE	1 330, 3	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-043

GENERAL ASSEMBLY SCALE 1:2

\$ my 01,30



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

(REF)

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Dart Ae	rospace L	td							
W/O:			WC	ORK ORDER CHANGES	3				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:			gory:	QA: N	C Close		Date: Date:	
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section I Action Description Chief Eng		Sign & Verification Section C		Approval Chief Eng	Approval QC Inspecto